

# Work Order ID 51353

August 20, 2009 8:50:52 AM



Page 1

Item ID: D3278-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: Support

Start Date: 21/08/2009 Start Qty: 40.00 51

Cust Item ID:

Required Date: 26/08/2009 Req'd Qty: 40.00

Customer:

Reference: *08-08-20*

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3278

Rev C

100



BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.00" x 1.00" x 2.550" long

*08/08/20*

51

0

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Machine as per Folio FA405 and Dwg D3278-2- Deburr and Tumble Identify as D3278-1

*08/09/08/22*

51

0

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

*08/09/08/22*

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Page 2

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Start Date: 21/08/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 26/08/2009 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

SL 09/08/23

Memo

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

(X51) MD 09/08/24

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

14112260

0.00

=> JV 09/08/21

(X51) Ø

START TIME: 2:45pm OVEN TEMPERATURE:

3:15pm FINISH TIME: 320°F

# Work Order ID 51353

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Item ID: D3278-1

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Setup Start



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Stop



Item Name: Support

Start Date: 21/08/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 26/08/2009 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

*Bl 09-08-24*

*(51)*



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: *78*

0.00



Packaging

Memo

0.00

Packaging

*Pc9/1/25 (51)*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/08/26 J Bl 09-8-25*

# Picklist Print

August 20, 2009 8:50:51 AM

Page 1

Work Order ID: 51353



Parent Item: D3278-1RevC



Parent Item Name: Support

Start Date: 21/08/2009

Required Date: 26/08/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	42.1700	9.8400			



6061-T6 Bar 1.00 x 2.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

42.17

107129

7.03

110829

2.14

111571

33

mt  
9/08/20

9.8175 + 1.9125

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	51353
<b>Description:</b> Support		<b>Part Number:</b>	D3278-1
<b>Inspection Dwg:</b> D3278 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

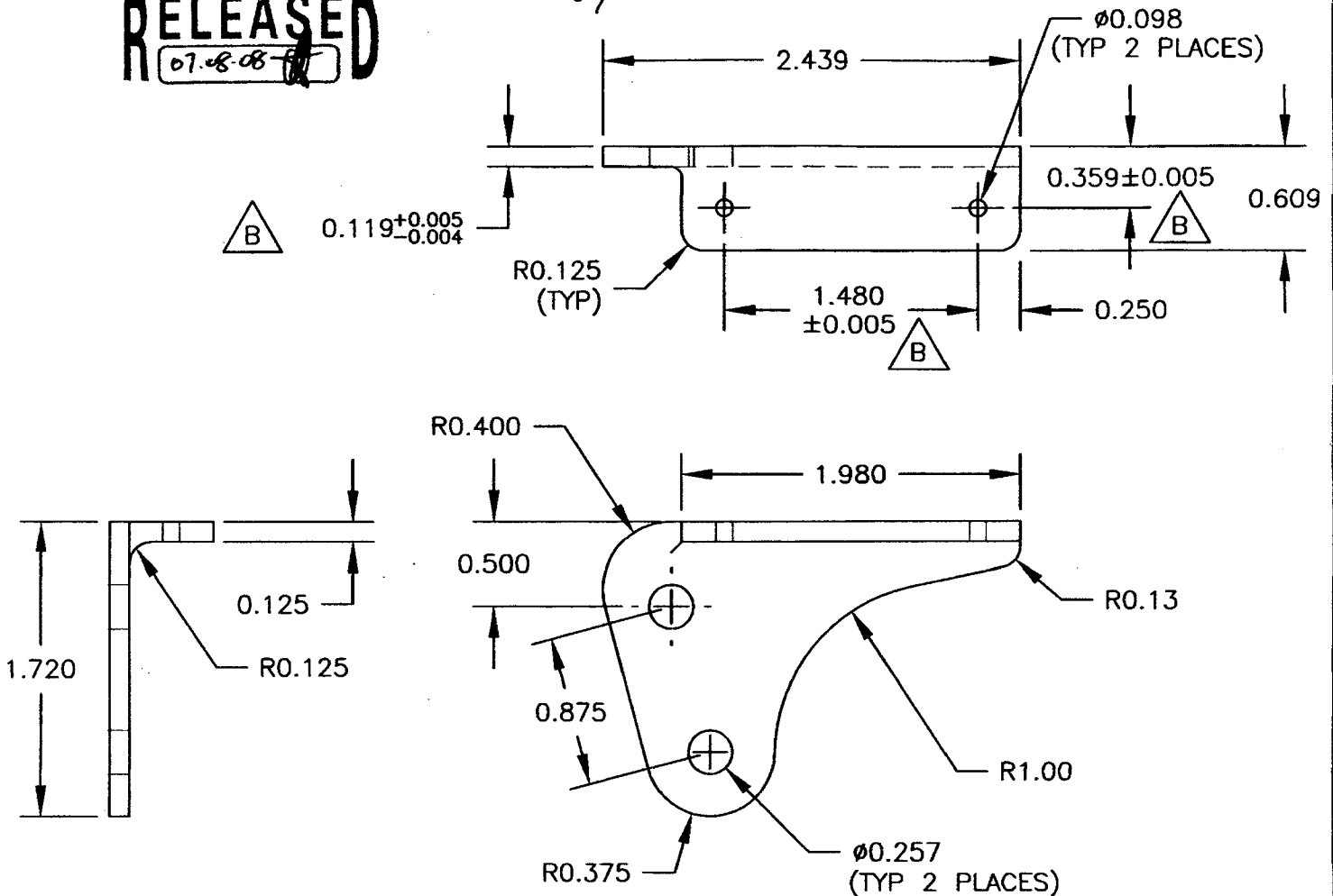
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.098	✓			
0.359	+/-0.005	.358	✓			
0.609	+/-0.010	.612	✓			
0.250	+/-0.010	.250	✓			
1.480	+/-0.005	1.479	✓			
R0.125	+/-0.010	R.125	✓			
0.119	+0.005/-0.004	.121	✓			
2.439	+/-0.010	2.438	✓			
1.980	+/-0.010	1.982	✓			
R0.13	+/-0.030	R.125	✓			
Ø0.257	+0.005/-0.000	Ø.259	✓			
R0.375	+/-0.010	R.375	✓			
0.875	+/-0.010	.875	✓			
0.500	+/-0.010	.500	✓			
R0.400	+/-0.010	R.400	✓			
R1.00	+/-0.030	R1.000	✓			
1.720	+/-0.010	1.720	✓			
R0.125	+/-0.010	R.125	✓			
0.125	+/-0.010	.127	✓			

<b>Measured by:</b>	AmL	<b>Audited by:</b>	JL	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	09/08/21	<b>Date:</b>	09/08/21	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	AF

**DART**

DESIGN <i>qp</i>	DRAWN BY <i>JC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

**RELEASED**  
07-08-08*w/o 51353***D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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